

ABSTRACT OF THE DISCLOSURE

A multi-roll calender for controlling the moisture gradient of a fibrous web and for enabling the manufacture of high quality paper grades, such as WFC, LWC-roto and SC-A by on- and off-line calendering. An on- or off-line multi-roll calender formed of
5 separate sets of rolls is used for calendering, and the fibrous web (W) is subjected to intermediate moistening between the sets of rolls (A, B).